

Work Order ID 52775

October 14, 2009 9:57:44 AM



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| | | | | | | |
|----------------|---------------|------------|------|-------|---------------|--|
| Item ID: | D2199-25 | Accept | | Setup | Start | |
| Revision ID: | E1 | | | | Stop | |
| Item Name: | Strut Details | | | | | |
| Start Date: | 14/10/2009 | Start Qty: | 4.00 | | Cust Item ID: | |
| Required Date: | 28/10/2009 | Req'd Qty: | 4.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|-----------|-------|-----------------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | <i>RF</i> | Date: | <i>09-10-14</i> | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| D2199 | Rev E1 | | | | | | | | |

| | | | | | | | | | |
|----------|---|------|-----------|-----------------|--|----------|----------|--|--|
| 100 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | Punch per Dwg D2199 and Spec Contol Dwg D2638 | | <i>SB</i> | <i>09/10/21</i> | | <i>4</i> | <i>6</i> | | |

| | | | | | | | | | |
|-----------|--------|------|------------|-----------------|--|-------------|--|--|--|
| 110 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Deburr | | <i>M.K</i> | <i>09/10/26</i> | | <i>(4X)</i> | | | |

| | | | | | | | | | |
|-----------------|---|------|-----------|-----------------|--|-------------|----------|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | <i>27</i> | <i>09/10/27</i> | | <i>(K4)</i> | <i>/</i> | | |

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Item ID: D2199-25

Accept



Setup Start



Revision ID: E1

Stop



Item Name: Strut Details

Start Date: 14/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo POWDER COAT: Start Time: 7:30AM Oven Temperature: 400°C Finish Time: 8:00AM | 0.00 0.00 | ⇒ MJ | 09/10/28 | | (X4) | Ø | | |
| 140 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | MD | 09/10/28 | | X4 | | | |
| 150 Packaging Packaging | Identify as per dwg & Stock Location: 264 Memo | 0.00 0.00 | | | | 9/10/28 | (X4) | | SJ |

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Item ID: D2199-25

Accept



Setup Start



Revision ID: E1

Stop



Item Name: Strut Details

Start Date: 14/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/29 JG
BS 0910-28

Picklist Print

October 14, 2009 9:57:55 AM

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1

Work Order ID: 52775



Parent Item: D2199-25RevE1



Parent Item Name: Strut Details

Start Date: 14/10/2009

Required Date: 28/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304TR0.750W.049 | | Purchased | No | | | 100 | f | 429.6711 | 7.0876 | | | |
| | | | | | | | | | | | | |

304 RD Tube .750 x .049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

429.6711

107518

2.77

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

112652

127.89

112800

269.3211

8

4 80 09/10/21

DART



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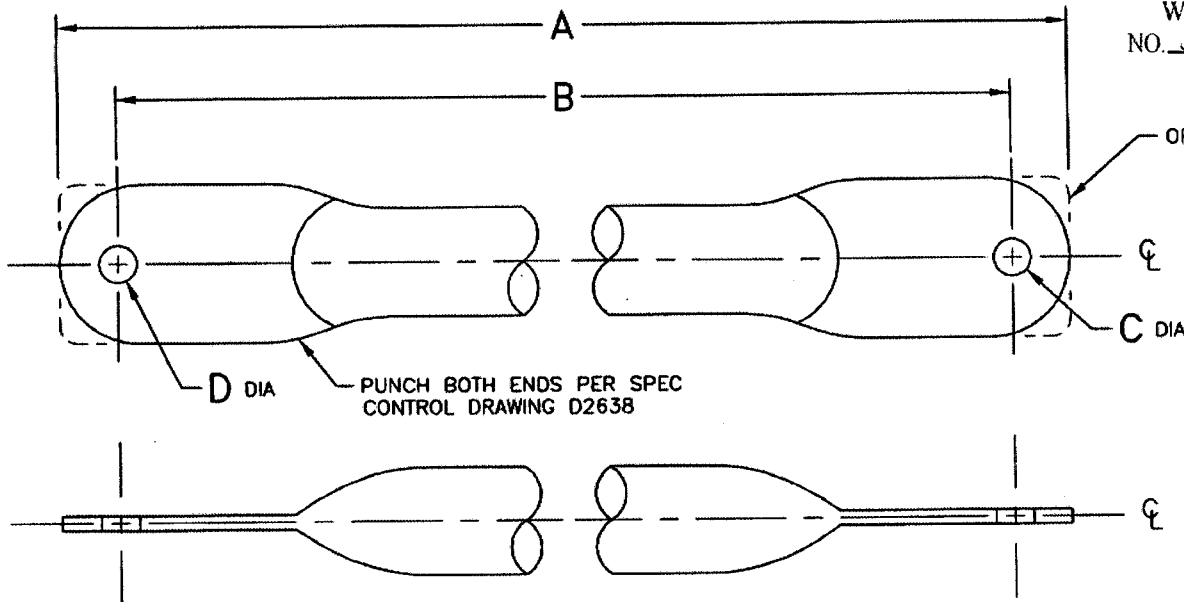
WITHOUT NOTICE

WORK ORDER

NO. 52775

BS 09-10-14

RELEASED
98.05.05/KE



OPTIONAL

C DIA

D DIA

PUNCH BOTH ENDS PER SPEC
CONTROL DRAWING D2638

| | A | B | C | D |
|----------|-------|-------|-------|-------|
| D2199-1 | 18.30 | 17.50 | 0.257 | 0.257 |
| D2199-3 | 5.80 | 5.00 | 0.257 | 0.257 |
| D2199-5 | 22.64 | 21.84 | 0.257 | 0.316 |
| D2199-7 | 14.74 | 13.94 | 0.257 | 0.257 |
| D2199-9 | 16.52 | 15.72 | 0.257 | 0.257 |
| D2199-11 | 23.60 | 22.80 | 0.257 | 0.316 |
| D2199-13 | 15.96 | 15.16 | 0.257 | 0.257 |
| D2199-15 | 17.57 | 16.77 | 0.257 | 0.257 |
| D2199-17 | 28.05 | 27.25 | 0.257 | 0.316 |
| D2199-19 | 18.90 | 18.10 | 0.257 | 0.257 |
| D2199-21 | 10.80 | 10.00 | 0.257 | 0.257 |
| D2199-23 | 26.18 | 25.38 | 0.257 | 0.316 |
| D2199-25 | 19.93 | 19.13 | 0.257 | 0.257 |
| D2199-27 | 27.34 | 26.54 | 0.257 | 0.316 |
| D2199-29 | 21.11 | 20.31 | 0.257 | 0.257 |

B
B
B
C
C
C
E
E

00.10.13
00.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART Q51 Q55 4.3/EI

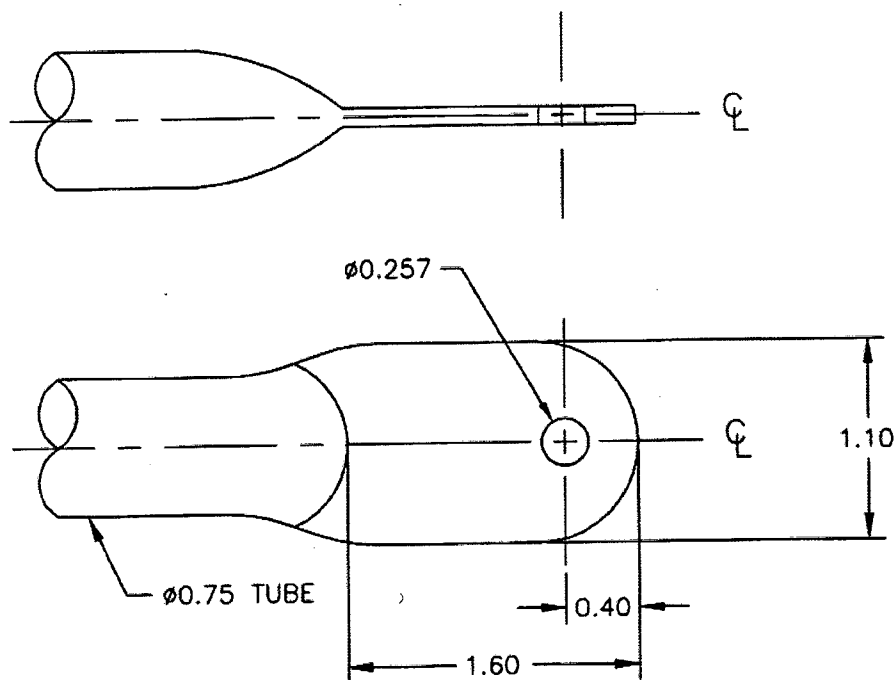
| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. E |
|----------|---------------|---|--------------|
| CHECKED | APPROVED | HAWKESBURY, ONTARIO, CANADA | |
| DATE | DRAWING NO. | | SHEET 1 OF 1 |
| 98.04.28 | D2199 | | |
| | TITLE | | SCALE |
| | STRUT DETAILS | | NTS |
| A | 1993 | NEW ISSUE | |
| B | | ADDED -11, -13, AND -15 | |
| C | | ADDED -17 AND -19 | |
| D | | ADDED -21 | |
| E | 98.04.28 | ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD | |
| E1 | 02.03.22 | ADD FINISH | |



| | | | |
|------------------|------------------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED DIB | APPROVED KE | DRAWING NO. D2638 | REV. A SHEET 1 OF 1 |
| DATE 98.04.28 | TITLE PUNCH DT8117 SPEC CONTROL | | SCALE 1:1 |
| A | 98.04.28 | NEW ISSUE | |

RELEASED
95/07/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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NO. 50277